

Work Order ID 63910

Thursday, November 18, 2010 3:54:16 PM

Page 1

Item ID: D4004-5

Accept

Revision ID:

Item Name: Bottom Strap Attach Bracket

Start Date: 11/26/2010 Start Qty: 4.00

Required Date: 12/3/2010 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: MF Date: 10-11-19 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4004	A
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100

0.00



Bandsaw

BAND SAW

Memo

0.00

Jeaspa Bandsaw

1-Cut D3033-144 extrusion to length per D4004-5 detail of dwg D3033

Ensure cut is started at correct place per dwg

Batch B30209

2-Deburr

(4X)
⇒ m-l w/12/07

105

0.00



Small Fab

Memo

0.00

Small Fab

Drill and c'sink holes as per dwg and trim part to length as required.

(4X)
⇒ m-l w/12/07

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D4004-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Bottom Strap Attach Bracket

Start Date: 11/26/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 12/3/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

QC5- Inspect part completeness to step on W/O

0.00

S101207



QC

Memo

0.00

(H)

Quality Control

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

H BL10-127

Hand Finishing

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

2) 11 10112107

x4

Quality Control

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item ID: D4004-5**Accept****Setup Start****Revision ID:****Stop****Item Name:** Bottom Strap Attach Bracket**Start Date:** 11/26/2010 **Start Qty:** 4.00**Cust Item ID:****Required Date:** 12/3/2010 **Req'd Qty:** 4.00**Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop****Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

140

Identify as per dwg & Stock Location: 109

0.00



Packaging

Memo

0.00

Packaging

10/12/07 sf (40)

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/08 sf (40)
Photo-8
(4)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 63910



Parent Item: D4004-5



Parent Item Name: Bottom Strap Attach Bracket

Start Date: 11/26/2010

Required Date: 12/3/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev A 09.12.15 new issue EC verified by:DD
10.05.17 as per ECN10-562 DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3033-144 Seat Track		Manufactured	No			100	f	32.9001	0.41	1.726316			

Location

ST492

30209

58045

Loc Qty

32.900142

2.900142

30

Loc Code

M-L w/12/07

1.72636

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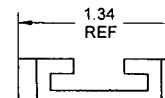
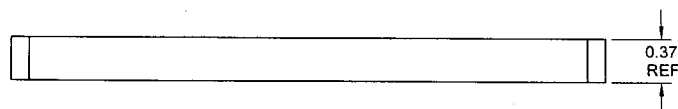
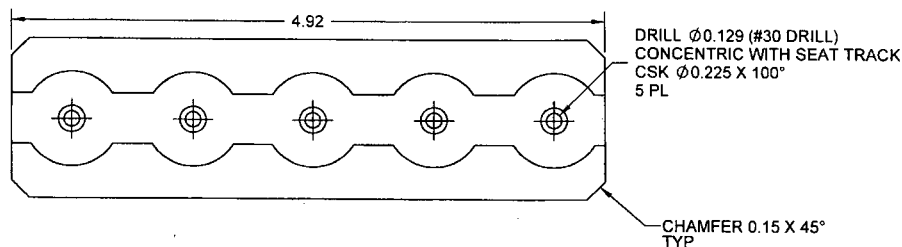
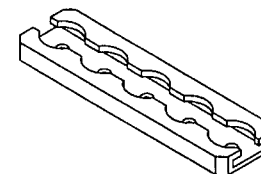
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4004-5	JCA-M47-2-23

63910



D4004-5 BOTTOM STRAP ATTACH BRACKET

RELEASED
2010-05-05
ND

NOTES:

- 1) MATERIAL: MADE FROM ANCRA P/N 40456-11-144 OR BROWNLIN P/N 20276-144-0-0 OR D3033-144
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4004-5" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.14 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4004	REV. A
MFG. APPR.			SHEET 7 OF 11
APPROVED		TITLE SIDE RESTRAINT	SCALE
DE APPR.			NTS
DATE	10.02.10	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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